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Indian Standard

FORESTRY TOOLS—RAKER ADJUSTER-*CUM*-SETTING IRON FOR TWO-MEN CROSS CUT SAWS—SPECIFICATION

भारतीय मानक

वानिकी औजार — रेकर एडजस्टर–कम–सेटिंग आयरन अनूप्रस्थ काट आरी के लिए — विशिष्टि

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MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

September 1989

Price Group 1

Forestry and Plantation Machinery Sectional Committee, AFDC 64

FOREWORD

This Indian Standard was adopted by the Bureau of Indian Standards on 24 April 1989, after the draft finalized by the Forestry and Plantation Machinery Sectional Committee had been approved by the Agricultural and Food Products Division Council.

Raker adjuster-cum-setting iron is used to maintain the height difference between the cutter and the raker teeth of the raker toothed cross cut saws. The groove marked as 0·3 will maintain the height difference of 0·3 mm between the cutter and the raker teeth and this difference is used while working on hard species wood. Similarly, the groove marked as 0·5 will maintain a height difference of 0·5 mm between the raker and the cutter, teeth and is used for soft species wood.

This tool can also be used to bend the cutter teeth alternately to the right and to the left in order to prevent the saw from binding or running heavily. By setting the saw, kerf is made little wider than the thickness of the blade to reduce the friction.

In the preparation of this standard, assistance has been derived from the Forest Operations Division, Forest Research Institute (ICFR), Dehra Dun.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be same as that of the specified value in this standard.

Indian Standard

FORESTRY TOOLS—RAKER ADJUSTER-*CUM*-SETTING IRON FOR TWO-MEN CROSS CUT SAWS—SPECIFICATION

1 SCOPE

1.1 This standard specifies the material, dimensions and other requirements for raker adjuster-*cum*-setting iron used for the maintenance of raker toothed two-men cross cut saws in accordance with IS 12127 : 1987 'Specification for two-men cross cut saws'.

2 REFERENCES

2.1 The following Indian Standards are necessary adjuncts to this standard.

IS No.	*Title*
IS 226 : 1975	Specification for structural steel (standard quality) (*fifth revision*)
IS 1570 (Part 3) : 1979	Schedules for wrought steel: Part 3 Carbon and carbon manganese free cutting steel (*first revision*)
IS 2102 (Part 1) : 1980	General tolerances for dimensions and form and position: Part 1 General tolerances for linear and angular dimensions (*second revision*)
IS 4905 : 1968	Methods for random sampling

3 MATERIAL

3.1 The raker adjuster-*cum*-setting iron shall be manufactured from mild steel (*see* IS 226 : 1975) with hard surface inserts. The hard surface inserts shall be made from high carbon steel [*see* IS 1570 (Part 3) : 1979] having hardness in the range of 65 ± 1 HRC.

4 SHAPE AND DIMENSION

4.1 The shape and dimensions shall be as given in Fig. 1.

4.2 Tolerances for various dimensions shall be very coarse class specified in IS 2102 (Part 1) : 1980 except for the slots and for those dimensions below 20 mm, for which these shall be ± 0·1 mm.

5 WORKMANSHIP AND FINISH

5.1 Raker adjuster-*cum*-setting iron shall be free from burrs, sharp edges, cracks, etc, and shall be finished smooth.

6 DESIGNATION

6.1 Raker adjuster-*cum*-setting iron shall be designated by its name and the number of this Indian Standard as:

Raker adjuster-*cum*-setting iron IS 12652

7 MARKING

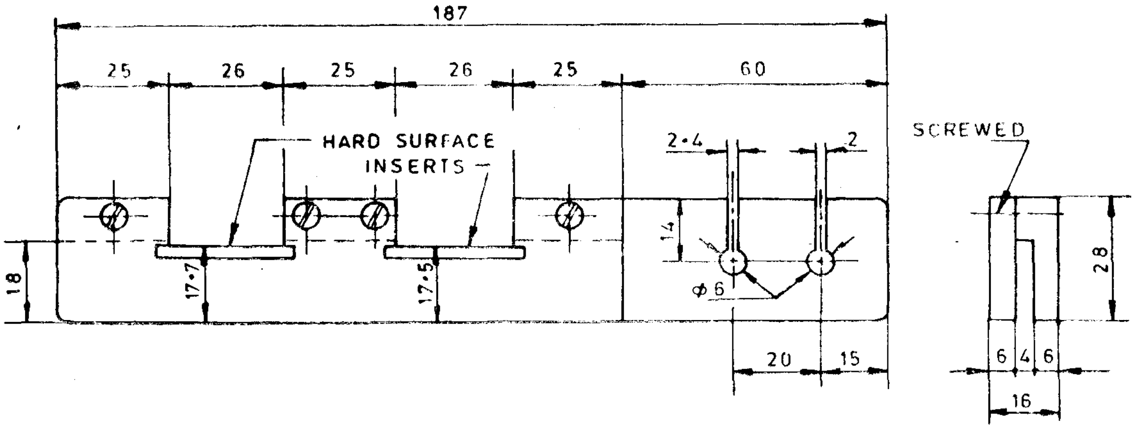
7.1 Setting iron shall be marked with the manufacturer's name or trade-mark, if any and the batch or code number.

8 PACKING

8.1 It shall be as agreed to between the purchaser and the supplier.

9 SAMPLING

9.1 Unless otherwise agreed to between the supplier and the purchaser, the sampling plan and criteria for conformity shall be as given in Annex A.



All dimensions in millimetres.

FIG. 1 RAKER ADJUSTER-*Cum*-SETTING IRON

ANNEX A

(*Clause* 9.1)

SCALE OF SAMPLING AND CRITERIA FOR CONFORMITY

A-1 SCALE OF SAMPLING

A-1.1 Lot

In any consignment, all the raker adjuster-*cum*-setting irons of the same nominal size manufactured under similar conditions of manufacture shall be grouped together to constitute a lot.

A-1.2 For ascertaining the conformity of the lot to the requirements of this specification, tests shall be carried out on the raker adjuster-*cum*-setting irons selected from each lot separately. The number of raker adjuster-*cum*-setting irons to be selected at random from a lot shall be in accordance with col 1 and 2 of Table 1. To ensure the randomness of selection, the procedure as laid down in IS 4905 : 1968 may be followed.

A-2 NUMBER OF TESTS AND CRITERIA FOR CONFORMITY

A-2.1 The raker adjuster-*cum*-setting irons selected according to **A-1.2** shall be examined for material (*see* **3**), dimensions (*see* **4**) and general requirements (*see* **5**). Any setting iron failing to meet the requirements for any one or more of the characteristics mentioned above shall be declared defective.

Table 1 Sampling Size and Permissible Number of Defectives

(*Clauses* A-1.2 and A-2.1.1)

Lot Size (1)	Sample Size (2)	Permissible Number of Defectives (3)
Up to 50	5	0
51 to 150	8	0
151 to 300	13	1
301 to 500	20	2
501 and above	32	3

A-2.1.1 The lot shall be considered conforming to the requirements of the characteristics mentioned in **A-2.1** if the number of setting irons found defective is less than or equal to the corresponding number given in col 3 of Table 1.

Standard Mark

The use of the Standard Mark is governed by the provisions of the *Bureau of Indian Standards Act, 1986* and the Rules and Regulations made thereunder. The Standard Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well defined system of inspection, testing and quality control which is devised and supervised by BIS and operated by the producer. Standard marked products are also continuously checked by BIS for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.